

# Work Order ID 70905

Friday, June 17, 2011 7:37:46 AM



Page 1

Item ID:	D3017-7	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Lug					
Start Date:	6/16/2011	Start Qty: 4.00		Cust Item ID:		
Required Date:	6/23/2011	Req'd Qty: 4.00		Customer:		
Reference:						

Approvals:	Process Plan:		Date:	6-17-11	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr	
D3017	Rev B	FAI A

100	FLOW WATER JET	0.00							
	Waterjet	0.00						FB 11-6-23	
FLOW CNC Waterjet	Memo								
4130.50	1-Cut as per Dwg D3017								
	Dwg Rev: B								
	Prog Rev: B								
	2-Deburr								

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC	0.00						FB 11-6-23	
Quality Control	Memo								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC8- Inspect parts - second check  Memo	0.00 0.00							
130  Brake NC Brake NC	NC BRAKE  Memo 1-Debur 2-Form as per Dwg D3017 using DT8598	0.00 0.00							
140  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00					11	07	21

8 u/06/23

SB u/07/21

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Item ID: D3017-7

Accept



Setup Start



Revision ID:

Stop



Item Name: Lug

Start Date: 6/16/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 6/23/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and bag with light oil (Vactra oil #2), then Stock Location <u>WA</u>								
160 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

11/7/21

11/7/22

11-07-21

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# Picklist Print

Friday, June 17, 2011 7:37:53 AM

Page 1

Work Order ID: 70905

Parent Item: D3017-7

Parent Item Name: Lug



Start Date: 6/16/2011

Required Date: 6/23/2011

Start Qty: 4.00


Required Qty: 4.00

## Comments:

IPP: ☐B☐03.05.09☐Reformat☐KJ/RF☐

IPP Rev:C 08-04-11 now made on water jet DD verified

by:EC IPP RevB: as per revB DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M4130NS.049  4130 Sheet .049		Purchased	No			100	sf	9.4000	0.102	0.429474			



B11-G-23

## Location

## Loc Qty

## Loc Code

MAT020

9.4

11612

9.4

11612

7

W/O:		WORK ORDER CHANGES					
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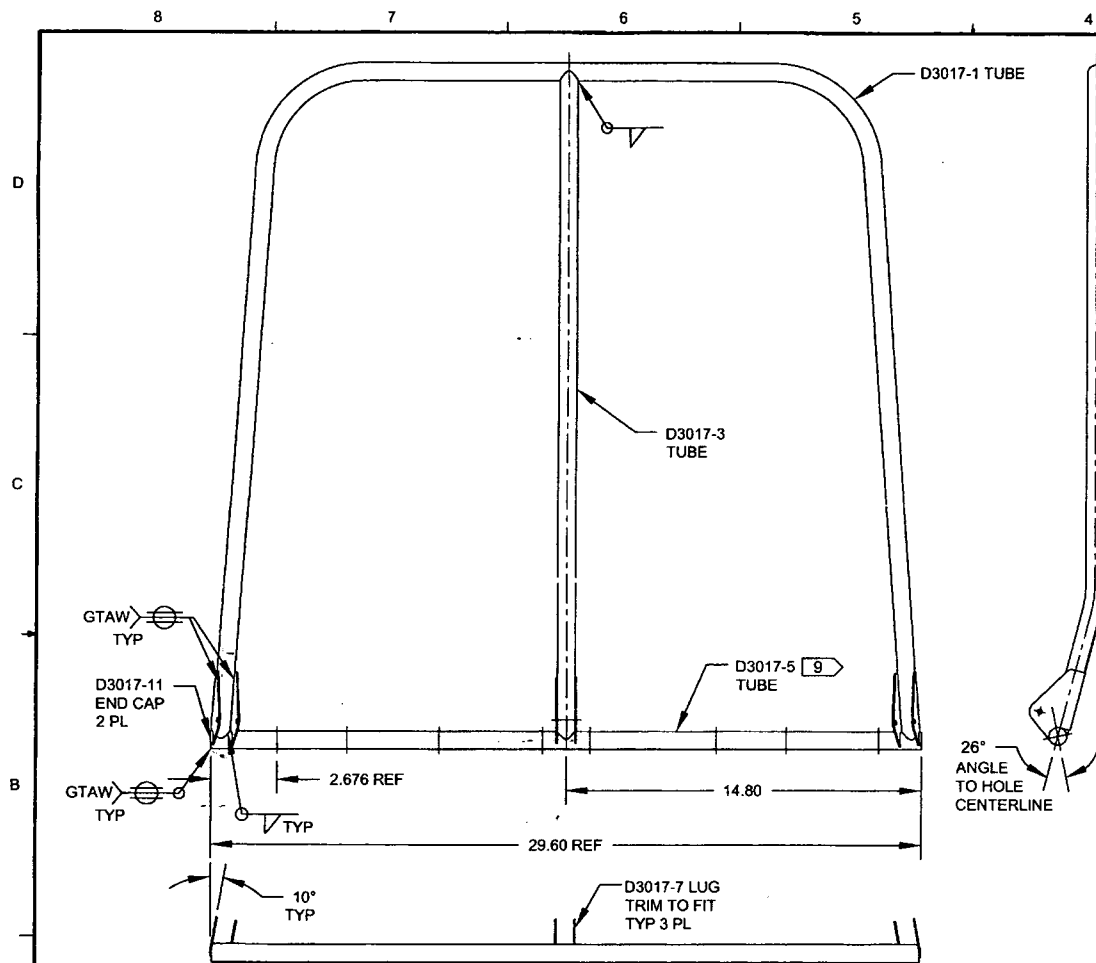
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ITEM No.	QTY	PART NUMBER	DESCRIPTION
1	X	D3017-041	BACK FRAME ASSEMBLY
2	1	D3017-1	TUBE
3	1	D3017-3	TUBE
4	1	D3017-5	TUBE
5	3	D3017-7	LUG
6	2	D3017-11	END CAP

DRILL 0.128 HOLES TO LINE UP  
WITH D3023-1 BACK PANEL

SHOP COPY

RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 70905

11-06-17

RELEASED  
2010-02-02  
WJP

### D3017-041 BACK FRAME ASSEMBLY

#### NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3017-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 4.50 lbs
- 8) WELD PER DART QSI 004
- 9) ROTATE SO THAT PILOT HOLES ARE ANGLED AS SHOWN IN END VIEW.

B	REFORMAT DWG, -5 TUBE WALL THKNS REVD (A8-3) SHEET 3 & 4 ADDED TO CLARIFY DRAWING. RADIUS CHANGED FROM R4.00 TO R3.75 (B4-2, B2-2). HOLE SIZE CHANGED FROM 0.191 TO 0.257 (C6-3, C3-3)	JPH	10.01.13
A	NEW ISSUE	CP	01.05.18
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.01.13		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. REV. B  
D3017 SHEET 1 OF 4  
TITLE SCALE  
BACK FRAME ASSEMBLY NTS

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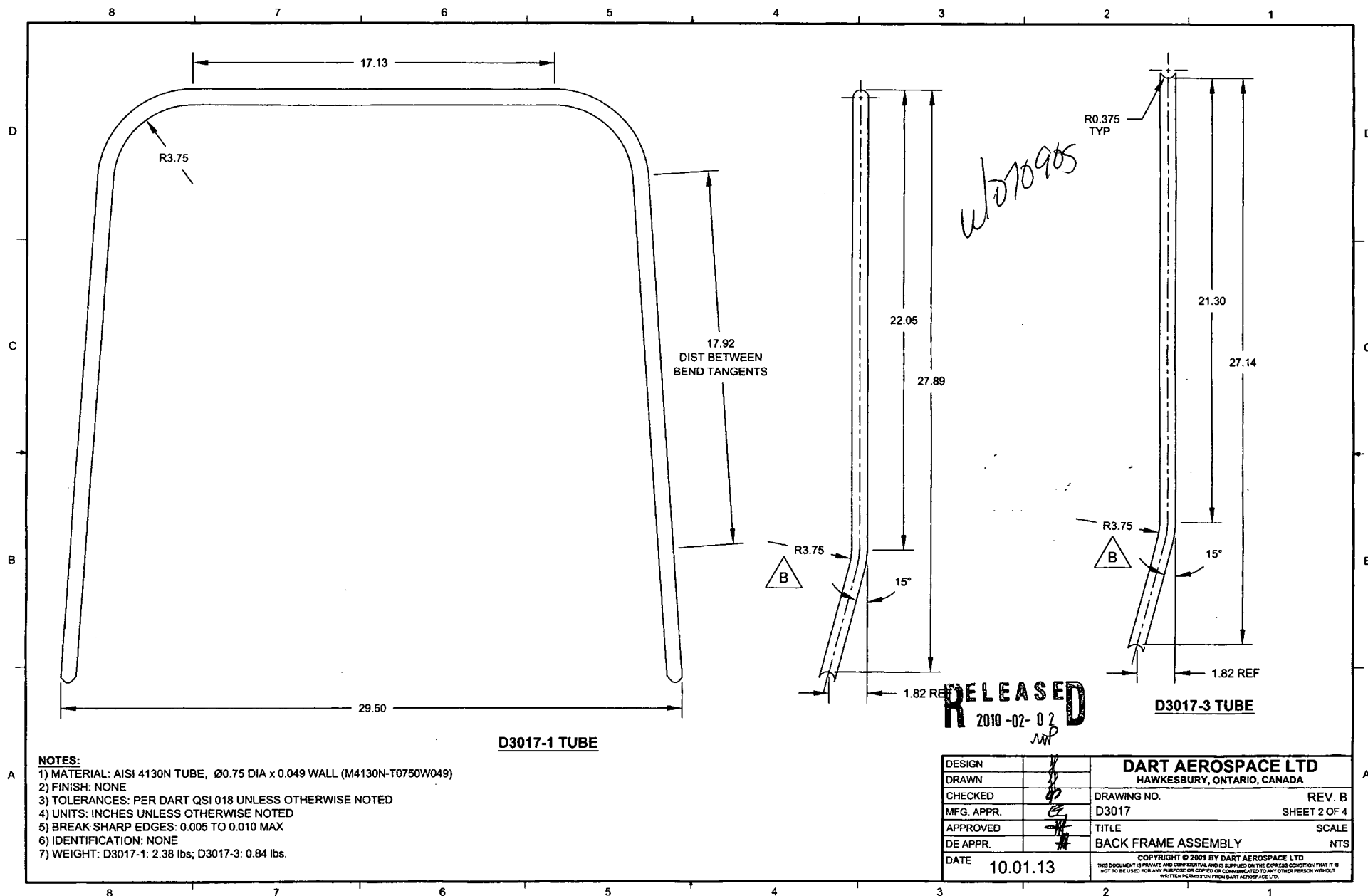
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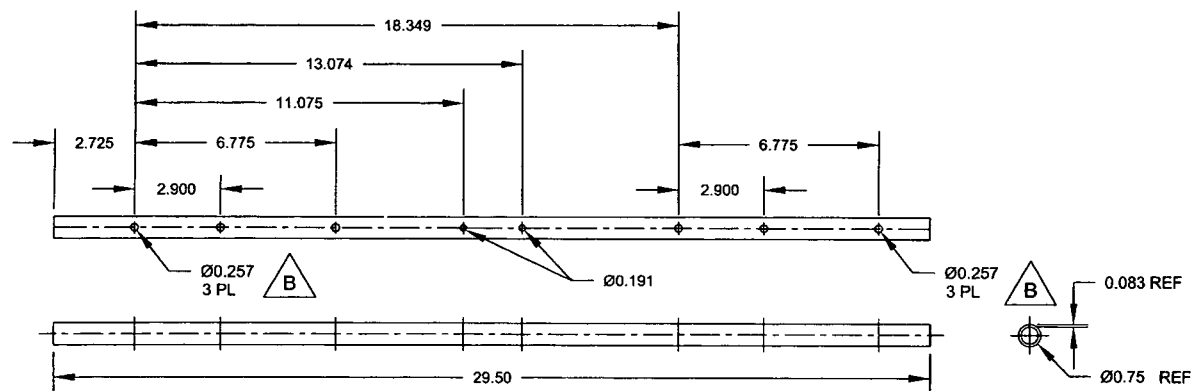
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**D3017-5 TUBE**

**RELEASED**  
2010-02-02  
*AMP*

- NOTES:**
- 1) MATERIAL: AISI 4130N TUBE, Ø0.75 DIA x 0.083 WALL (M4130N-T0750W083)
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 0.89 lbs



DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3017	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BACK FRAME ASSEMBLY	NTS
DATE	10.01.13	<small>COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
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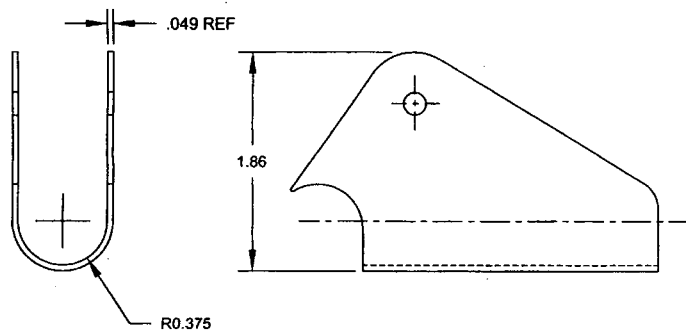
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D

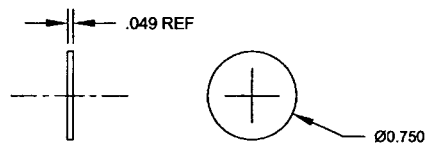
C

B

A



**D3017-7 LUG**  
BENDING DETAIL  
MAKE FROM D3017-7F



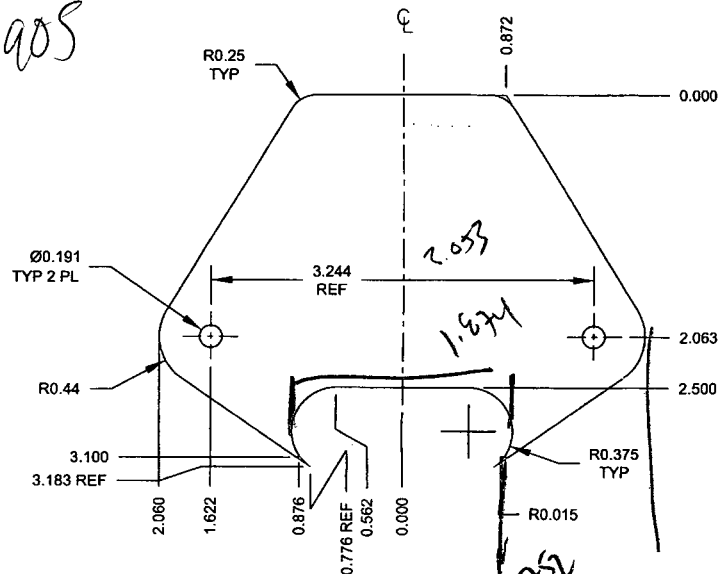
**D3017-11 END CAP**

**NOTES:**

- 1) MATERIAL: AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: -7: 0.12 lbs; -11: 0.01 lbs.

8 7 6 5 4 3 2 1

*u1070905*



**D3017-7F FLAT PATTERN**  
PART IS SYMMETRIC  
ABOUT CENTERLINE

**RELEASED**  
2010-02-02  
*MP*

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3017	SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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